

Split

Ship July 15

Work Order ID 60162-1

June 28, 2010 11:49:19 AM



Page 1

Item ID: D4132-041

Revision ID:

Item Name: Wearplate, L11 Fwd

Start Date: 6/29/10 Start Qty: 2.00

Required Date: 7/15/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

H

Date: 10-6-29 Tooling:



Cust Item ID:

Customer:

QC:

Date: SPC (Y/N):

Date:

Setup Start

Stop

Setup Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

D4132

A

100



Waterjet

FLOW WATER JET

FLOW CNC Waterjet

304.000

110



QC

Quality Control

120



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

0.00

0.00

0.00

0.00

0.00

FLOW WATER JET

Memo

1-Cut D4132-AW as per Dwg D4132

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

Memo

Memo

QC8- Inspect parts - second check

8 whole 30

10-6-29

10-6-29

(3)

PF

| W/O: | | WORK ORDER CHANGES | | | | |
|------|------|--------------------|----|------|-----|-------------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Prod Mgr |
| | | | | | | |
| | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
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NOTE: Date & initial all entries

Work Order ID 60162

Wednesday, July 14, 2010 4:13:27 PM



Item ID: D4132-041

Accept

Setup

Start



Stop



Revision ID:

Item Name: Wearplate, LH Fwd

Start Date: 6/29/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Brake NC

Brake NC

Operation
DescriptionForm as per dwg
NC BRAKESet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

0.00

10.07.14

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

P
10.07.14H
10.07.14 1
P

150



Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: 1114105 0.00

Large Fab

Memo

0.00

Weld hard surface using DT N/A as per QSI 004 and Dwg D4132

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 60162

June 28, 2010 11:49:20 AM



Page 3

Item ID: D4132-041

Accept



Setup

Start



Stop



Revision ID:

Item Name: Wearplate, LH Fwd

Start Date: 6/29/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

8/20/2010

RQ

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10-07-14 ①

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NOTE: Date & initial all entries

Work Order ID 60162

June 28, 2010 11:49:21 AM



Page 4

Item ID: D4132-041

Accept



Setup Start



Stop



Revision ID:

Item Name: Wearplate, LH Fwd

Start Date: 6/29/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Memo

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

M 10/07/15

y 1 6

200



Small Fab

Small Fab

Memo

0.00

0.00

1- Bond D4132-3 gasket to inner surface of wearplate using a thin layer of 3M
1300/13001, scotch grip adhesive

Batch: M113174

1X
7M/L 10/07/15

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

B 10-07-15 0

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

June 28, 2010 11:49:19 AM

Work Order ID: 60162



Parent Item: D4132-041



Parent Item Name: Wearplate, LH Fwd

Start Date: 6/29/10

Required Date: 7/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|------------|
| D4132-3 | | Manufactured | No | | | 200 | Each | 0.0000 | | | 2 | 2x | M/L Work/s |
| Gasket M304S18GA | | Purchased | No | | | 100 | sf | 132.8779 | 1.555 | 3.273684 | | 4665 | 18 10-6 20 |

304/316 .050 Sheet

| Location | Loc Qty | Loc Code |
|----------|----------|----------|
| MAT20 | 132.8779 | |
| 111743 | 8.86 | |
| 112885 | 28.0179 | |
| 113062 | 96 | |

113062

B

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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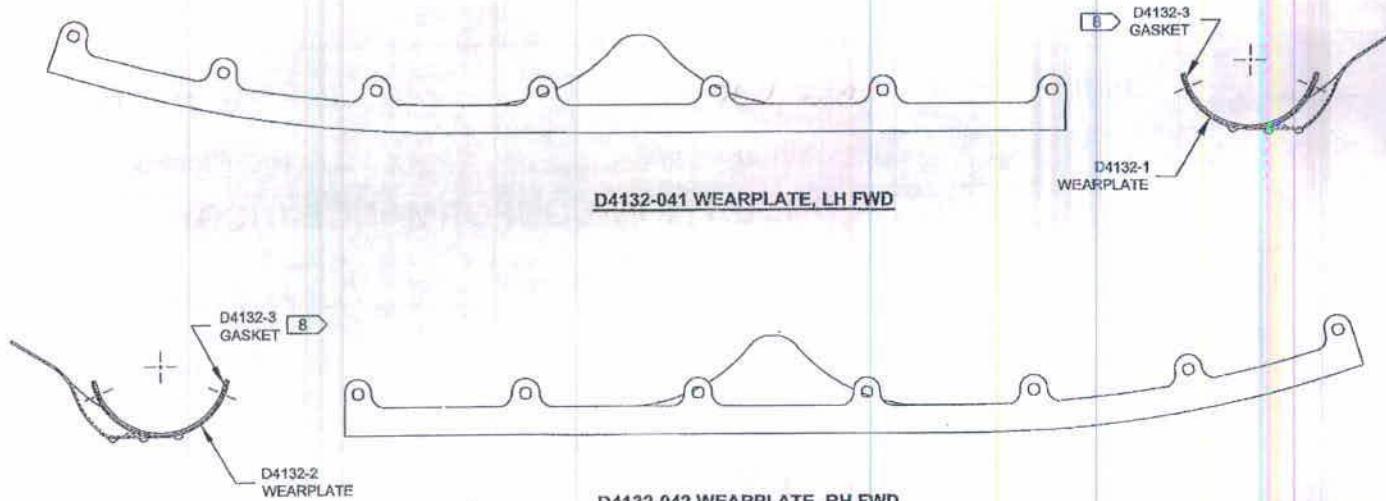
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NOTE: Date & initial all entries

SUB-ASSEMBLY
RETAINER
PNEUMATIC
UNCONTROLLED
SUBJECT TO AMENDMENT
3 WELDING SPEC. 2
1

| QTY | QTY | PART NUMBER | DESCRIPTION |
|------|------|--------------|-------------------------|
| -041 | -042 | | |
| X | | D4132-041 | WEARPLATE, LH FWD |
| X | | D4132-042 | WEARPLATE, RH FWD |
| 1 | | D4132-1 | WEARPLATE |
| 1 | 1 | D4132-2 | WEARPLATE |
| 1 | 1 | D4132-3 | GASKET |
| A/R | A/R | 1300 / 1300L | 3M SCOTCH-GRIP ADHESIVE |

Weld, Center
NO. 69162
3810-6-29



NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4132-xxx" USING YELLOW PAINT MARKER ON INSIDE SURFACE
 7) WEIGHT: -041/-042 = 2.1 lbs
 8) BOND D4132-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

| A | NEW ISSUE | CP | 10.06.15 |
|------------|-------------|--|--------------|
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 99 | DART AEROSPACE USA, INC | |
| DRAWN | 99 | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D4132 | SHEET 1 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARPLATE, FWD | NTS |
| DATE | 10.06.15 | COPYRIGHT © 2015 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRINTED AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED OR COPIED EXCEPT WITH THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC | |

RELEASED
2010-06-23
MP

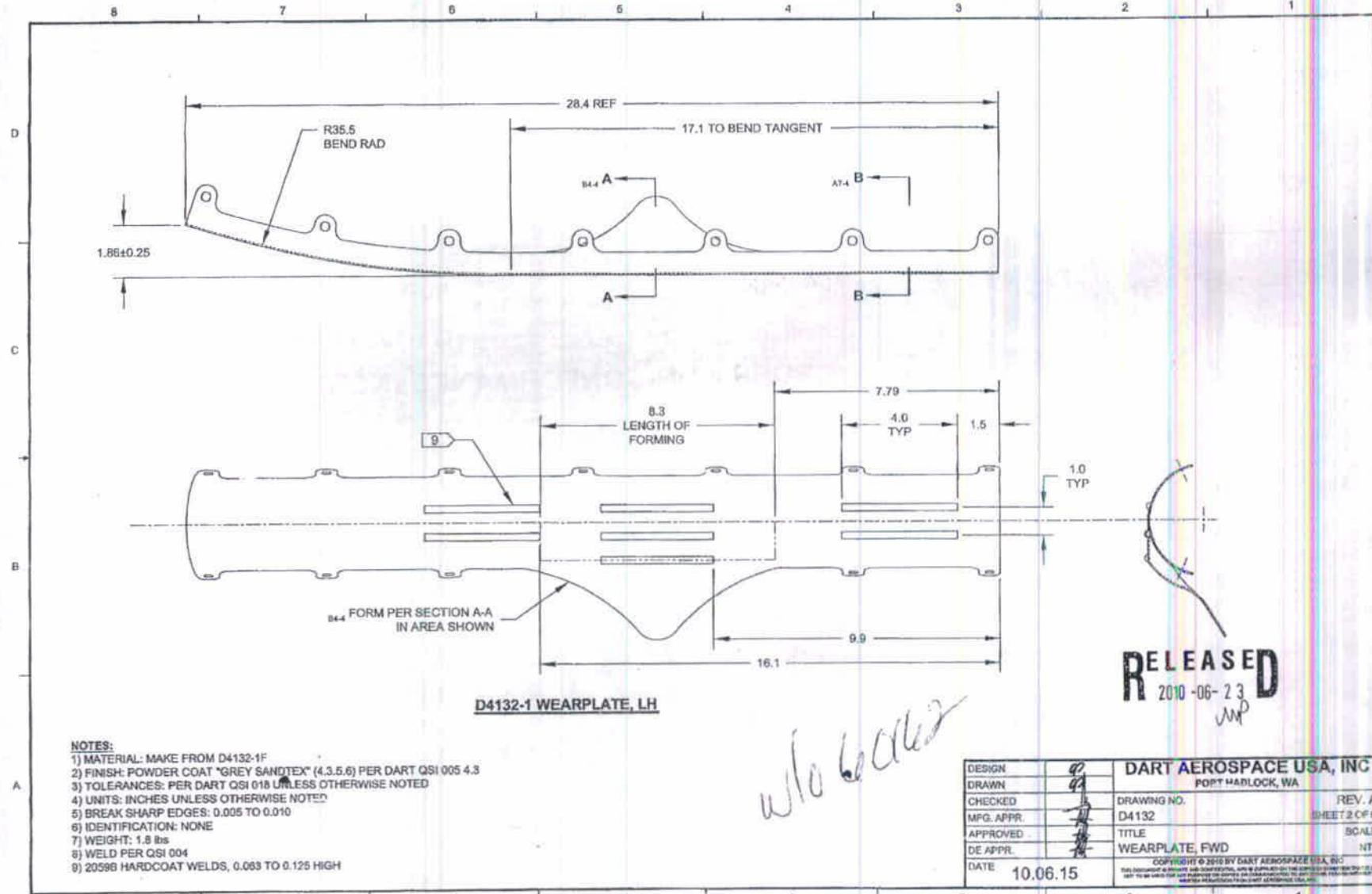
| W/O: | | WORK ORDER CHANGES | | | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: MAKE FROM D4132-1F
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) WELD PER QSI 004
- 9) 20596 HARDCOAT WELDS, 0.063 TO 0.125 HIGH

WFO 6/24/15

| | | |
|------------|----------|-------------------------|
| DESIGN | 99 | DART AEROSPACE USA, INC |
| DRAWN | 99 | PORT HABLOCK, WA |
| CHECKED | | REV. A |
| MPG. APPR. | 1 | DRAWING NO. |
| APPROVED | 1 | D4132 |
| DE APPR. | 1 | SHEET 2 OF 8 |
| DATE | 10.06.15 | SCALE |
| | | NTS |

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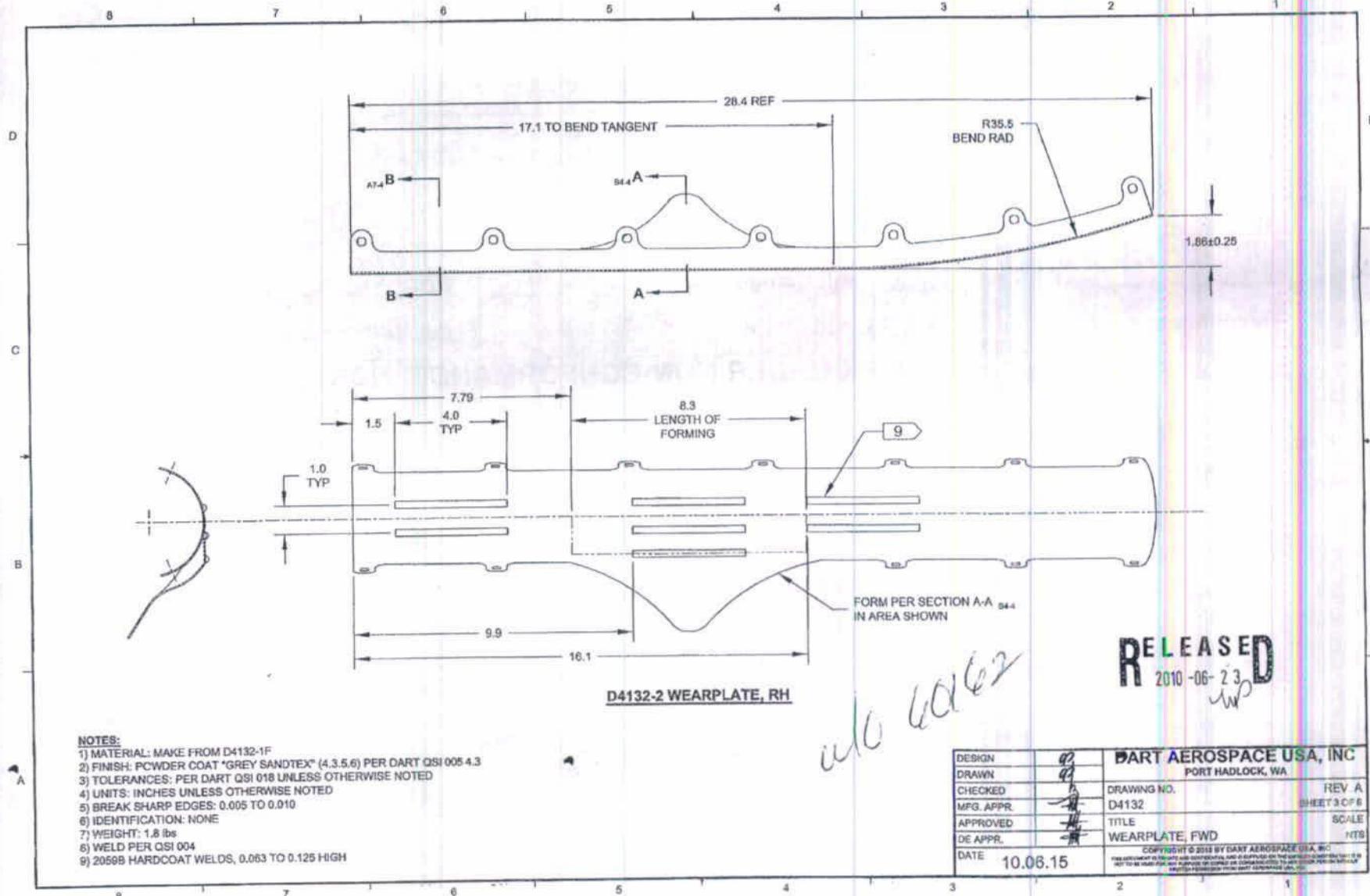
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|------------|----------|-------------------------|
| DESIGN | 93 | DART AEROSPACE USA, INC |
| DRAWN | 93 | PORT HADLOCK, WA |
| CHECKED | | REV. A |
| MFG. APPR. | | D4132 |
| APPROVED | | SHEET 3 OF 6 |
| DE APPR. | | TITLE |
| DATE | 10.06.15 | WEARPLATE, FWD |

RELEASED
2010-06-23
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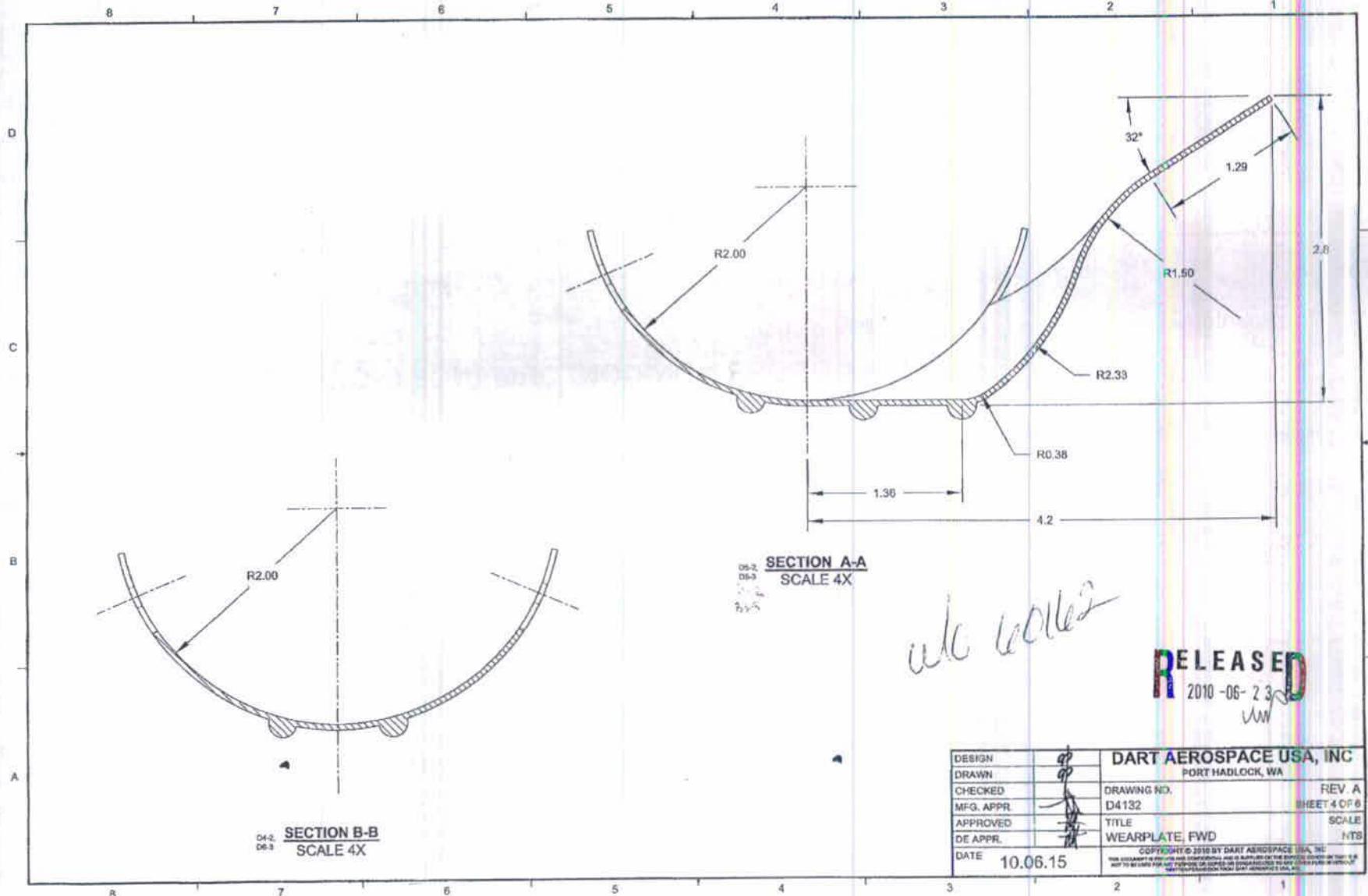
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NOTE: Date & initial all entries



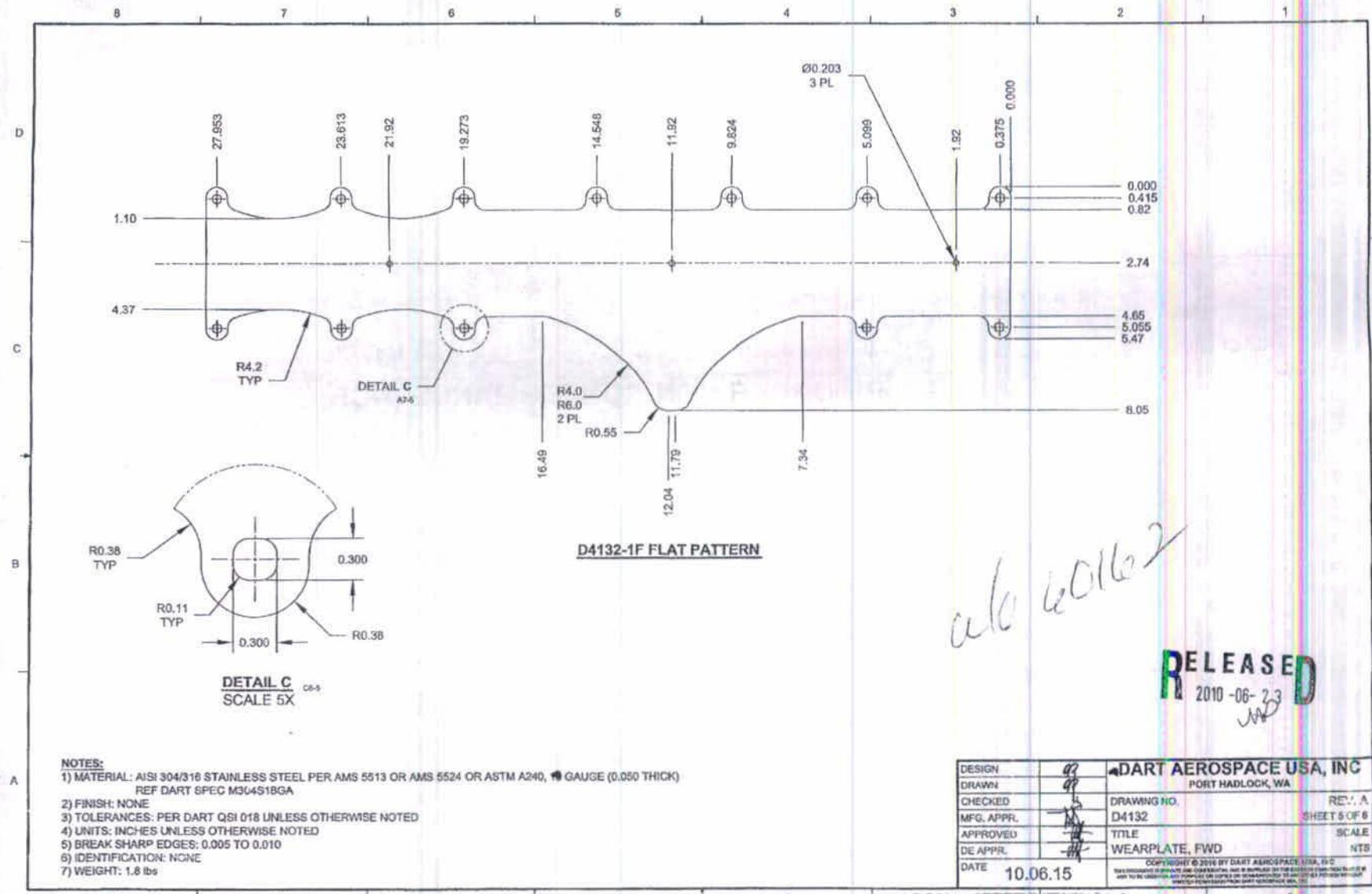
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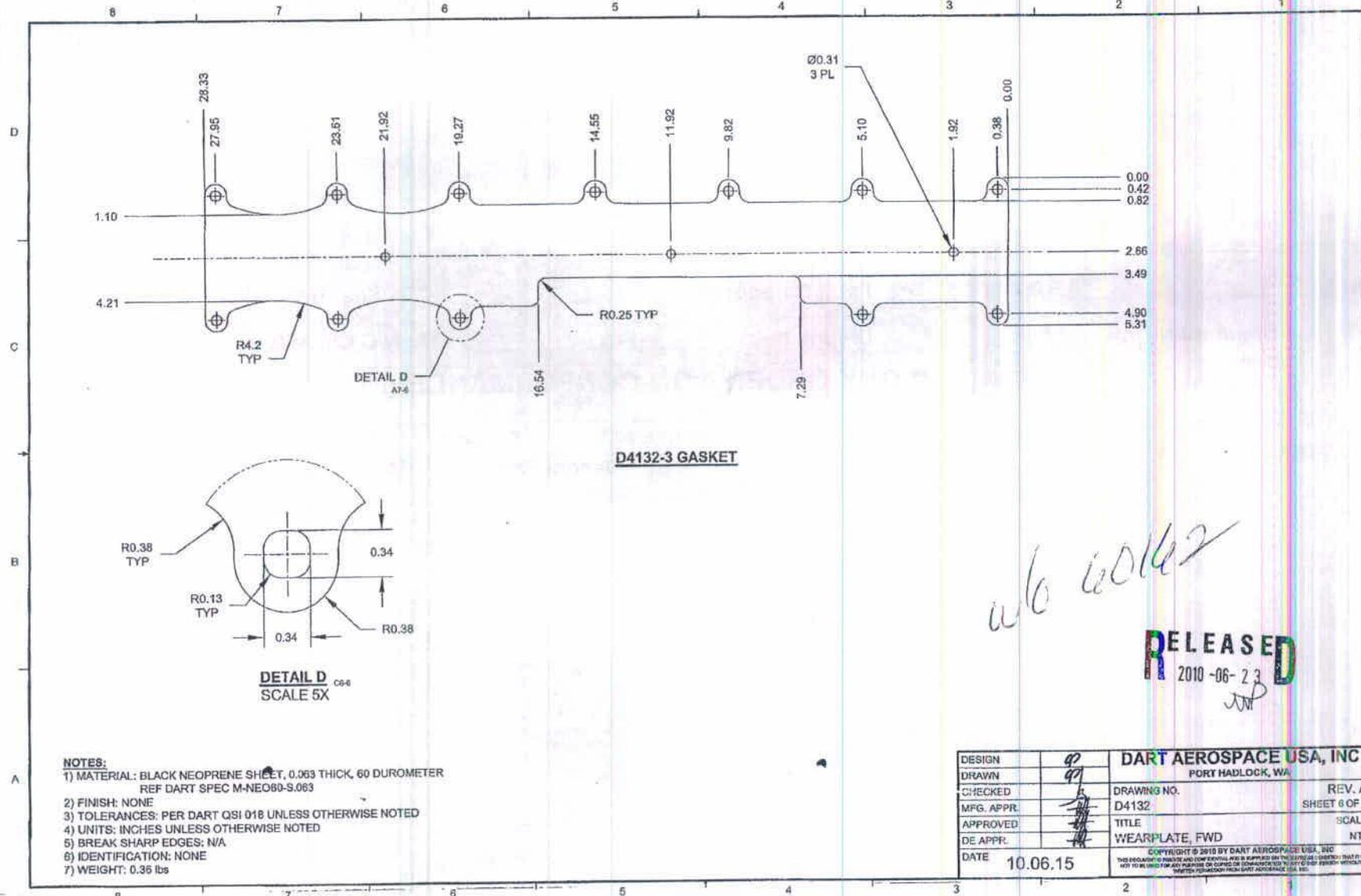
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

DART AEROSPACE LTD
 Description: WEARPLATE LH Fwd
 Inspection Dwg: DM132-1 Rev: #

Work Order: 60162
 Part Number: D413.7-641
 Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|------------|------------------|--------|--------|----------------------|----------|
| .300X300 | +.010 | .302X303 | X | | | |
| .303 | +.005-.001 | .304 | X | | | |
| .415 | +.010 | .413 | X | | | |
| .87 | +.030 | .823 | X | | | |
| 2.74 | +.030 | 2.731 | X | | | |
| 4.65 | +.030 | 4.638 | X | | | |
| 5.055 | +.010 | 5.054 | X | | | |
| 5.47 | +.030 | 5.467 | X | | | |
| 8.05 | +.030 | 8.043 | X | | | |
| .315 | +.000 | .317 | X | | | |
| 1.92 | +.030 | 1.917 | X | | | |
| 5.094 | +.010 | 5.099 | X | | | |
| 9.824 | +.010 | 9.824 | X | | | |
| 11.92 | +.030 | 11.97 | X | | | |
| 14.548 | +.010 | 14.549 | X | | | |
| 19.773 | +.010 | 19.773 | X | | | |
| 21.42 | +.020 | 21.42 | X | | | |
| 23.613 | +.020 | 23.613 | X | | | |
| 27.953 | +.010 | 27.953 | X | | | |
| 1.10 | +.030 | 1.092 | X | | | |
| 4.37 | +.020 | 4.361 | X | | | |
| 11.79 | +.030 | 11.79 | X | | | |
| 17.04 | +.030 | 17.04 | X | | | |
| .050 | +.010 | .050 | X | | | |

Measured by: HR
 Date: 10-6-29

Audited by: 
 Date: 10/06/30

Prototype Approval: N/A
 Date: N/A

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:

| | | WORK ORDER CHANGES | | | | | |
|----------|------|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 10/07/13 | 130 | Had to open Rote at .311 to match the jig | SB | 10/07/13 | ③ | 10/07/13 QSI 042 | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Date & initial all entries